



Abstract of the Disclosure

A progressive die for shaping a consecutive series of discs from a strip of relatively stiff material, comprising a series of adjacent die stations including a slot cutting station, a plurality of intermediate stations, and a cut off station, the slot cutting station including cutting means for forming at least one laterally extending slot between adjacent discs while leaving at least one narrow deformable bridge connecting the adjacent discs, the intermediate stations including cutting means for shaping the discs, and the cut off station including cutting means for severing the bridge. A strip of relatively stiff material includes a series of consecutive discs formed along the length thereof, at least two adjacent discs having at least one laterally extending slot therebetween and at least one narrow deformable bridge connecting the adjacent discs. A process for die punching a series of shaped discs from a strip of relatively stiff material comprises the steps of cutting at least one slot through the strip between each pair of adjacent sections and forming at least one narrow deformable bridge connecting each pair of adjacent discs, shaping the discs between the bridges, and severing the bridges.